

Date: Monday, 11/08/2008 10:09:05 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH  
 Job Number : 41094  
 Estimate Number : 10265  
 P.O. Number :  
 This Issue : 11/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11/08/2008 Type : SKIDTUBES  
 Previous Run : 41059  
 Part Number : D350636012  
 Drawing Number : D2750 UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision :  
 Material :  
 Due Date : 30/08/2008 Qty: 1 Um: Each

Written By :  
 Checked & Approved By : JLD 08.8.11  
 Comment : Est Rev:I 02.09.25 Rearranged procedure steps KJ  
 Est Rev:J 06-03-29 As per Rev D EC  
 Est Rev:K 06-07.13 As per dsi9343 EC  
 Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By:EC  
 Est Rev:M 08-04-22 update steps 4,13 DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.8.26



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B39714

D M 7-8-13

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B37768

D M 7-8-13

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8863.

M  
7-8-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

\*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m107877/m108096* *BE 08-08-14*

10-Grind welds flush as per Dwg D2750 *SL 8-8-14*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *208-08-14*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *208-08-14*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *AWM 8-8-14*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *DP 8-8-15*

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B41127* *SL 8-8-15*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 31584

SL 8-8-18

(4)

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 40727

SL 8-8-18

(4)

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: 38755

SL 8-8-18

(8)

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on  
sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 106901

exp. date: 8-10-1

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 4)

SL 8-8-15

8-8-15

**Dart Aerospace Ltd**

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R

Aluminum Rod .

batch:

M 108096

RE 08-08-19

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Deburr holes

8-8-20

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/22 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/22 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL

08-08-25 (X)

17.0

POWDER COATING

POWDER COATING



M 108523



(X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
320°F  
4:00

M-L 08/08/25

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-08-26 (X)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Insert

Batch: M100489

HL 08-08-26 (X)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

JS 08-08-26

(X1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B36230

JS

22.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39716

JS

23.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40729

JS

24.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B38941

JS

25.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B39694

JS

26.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B40551

JS

08-08-26

(X1)

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

1340552

JH

28.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

1340553

JH

29.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

1339713

JH

30.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Phenolic Washer

1339275

JH

31.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M108062

JH

32.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

M108079

JH

33.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: 1338139

JH

34.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: 1338787

JH

08.08.26

CU

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B41058

JH

36.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B41090

JH

37.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M108744

JH

38.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105300

JH

39.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M109091

JH

40.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896

JH

41.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M108618

JH

08-08-26

JD

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960C816L

WASHER



1 # 08.07.12

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M1107520

JK

43.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M1108744

JK

44.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M1108880

JK

45.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M11089604

JK

46.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch:

NOT REQ'D  
# 06.08.12

47.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: M1107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M1108801

EXP DATE: 08/10

JK 08-08-26

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Date: Monday, 11/08/2008 10:09:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch: M10425

910

08-08-26

(XL)

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/27 (P)

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B38558

sq

51.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

sq

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M108800

sq

53.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107924

sq

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107587

8/8/29

sq

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 11/08/2008 10:09:05 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41094

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B40829

50

58.0

D35321

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

spacer

Batch: B38594

8/8/29

(x)

50

57.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

See below

58.0

PACKAGING 1

PACKAGING RESOURCE #1



10272 Rev G



8/1/2 (1)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

CHG 004 08.08.12

50

59.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/02

Job Completion



08/08/02

B41094

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                         |                       |   |                        |
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| CHECKED<br><i>PH</i>    | APPROVED<br><i>HA</i> | DRAWING NO.<br><b>D2750</b>   | REV. E<br>SHEET 1 OF 5 |
| DATE<br><b>07.05.17</b> |                       | TITLE<br><b>350 SKIDTUBE ASSEMBLY</b><br>SCALE<br>NTS   |                        |
| REV                     | DATE                  | DESCRIPTION   |                        |
| A                       | 98.04.16              | NEW ISSUE   |                        |
| B                       | 98.09.01              | CHANGE MS24694-S293 TO AN8-16A  |                        |
| C                       | 98.11.18              | ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740  |                        |
| D                       | 06.01.05              | ADD HOLES AND SPACERS FOR APICAL FLOATS<br>INCORPORATE DEO 9133 / 9157  |                        |
| E                       | 07.05.17              | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS; CHANGE INSERTS;<br>ADD D3631-1; REMOVE QTY(38) NAS1515H3L;<br>REMOVE QTY(10) NAS1515H8L;<br>REMOVE D2741, QTY(2) AN960C816;<br>REMOVE QTY(2) MS21083C8 |                        |

RELEASED  
07.08.02

| Qty<br>-041 | Qty<br>-042 | Qty<br>-043 | Qty<br>-044 | Part Number   | Description  |
|-------------|-------------|-------------|-------------|---------------|--|
| X           |             |             |             | D2750-041     | SKIDTUBE ASSEMBLY, LH                                      |
|             | X           |             |             | D2750-042     | SKIDTUBE ASSEMBLY, RH                                      |
|             |             | X           |             | D2750-043     | SKIDTUBE ASSEMBLY, LH                                      |
|             |             |             | X           | D2750-044     | SKIDTUBE ASSEMBLY, RH                                      |
| 1           | 1           | 1           | 1           | D2739         | WEB  |
| 8           | 8           | 8           | 8           | D2743         | SPACER   |
| 1           | 1           | 1           | 1           | D2744         | CAP  |
| 8           | 8           | 8           | 8           | D2745         | BUSHING  |
| 1           |             |             |             | D2750-1       | SKIDTUBE WELDMENT, LH                                      |
|             | 1           |             |             | D2750-2       | SKIDTUBE WELDMENT, RH                                      |
|             |             | 1           |             | D2750-3       | SKIDTUBE WELDMENT, LH                                      |
|             |             |             | 1           | D2750-4       | SKIDTUBE WELDMENT, RH                                      |
| 1           |             | 1           |             | D3488-041     | BLADE FITTING, LH  |
|             | 1           |             | 1           | D3488-042     | BLADE FITTING, RH  |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER   |
| 4           | 4           |             |             | D3490-3       | SPACER   |
|             |             | 4           | 4           | D3490-5       | SPACER   |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY  |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY  |
|             |             | 8           | 8           | D3492-045     | PLUG ASSEMBLY  |
| 1           | 1           | 1           | 1           | D3535-13      | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3535-25      | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3535-35      | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3536-13      | GASKET   |
| 1           | 1           | 1           | 1           | D3536-25      | GASKET   |
| 1           | 1           | 1           | 1           | D3536-35      | GASKET   |
| 5           | 5           | 5           | 5           | D3537-1       | WEARPAD  |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER   |
| 42          | 42          | 42          | 42          | ALS4-1032-225 | INSERT (OR ALS7-1032-225,<br>AKS4-1032-225, AELS-1032-225) |
| 38          | 38          | 38          | 38          | AN3C5A        | BOLT   |
| 4           | 4           | 4           | 4           | AN3C6A        | BOLT   |
| 4           | 4           | 4           | 4           | AN3C7A        | BOLT   |
| 4           | 4           | 4           | 4           | AN6C44A       | BOLT   |
| 1           | 1           | 1           | 1           | AN8C35A       | BOLT   |
| 46          | 46          | 46          | 46          | AN960C10L     | WASHER   |
| 2           | 2           | 2           | 2           | AN960C816L    | WASHER   |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT  |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT  |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER   |
| 2           | 2           | 2           | 2           | NAS1515H8L    | WASHER   |

*PH 08.08.12*  
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*08.08.12*  
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PER  
DSI 9419

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| CHECKED<br>PH    | APPROVED<br>[Signature] | DRAWING NO.<br>D2750                                | REV. E<br>SHEET 2 OF 5 |
| DATE<br>07.05.17 |                         | TITLE<br>350 SKIDTUBE ASSEMBLY                      | SCALE<br>NTS           |

GENERAL NOTES:

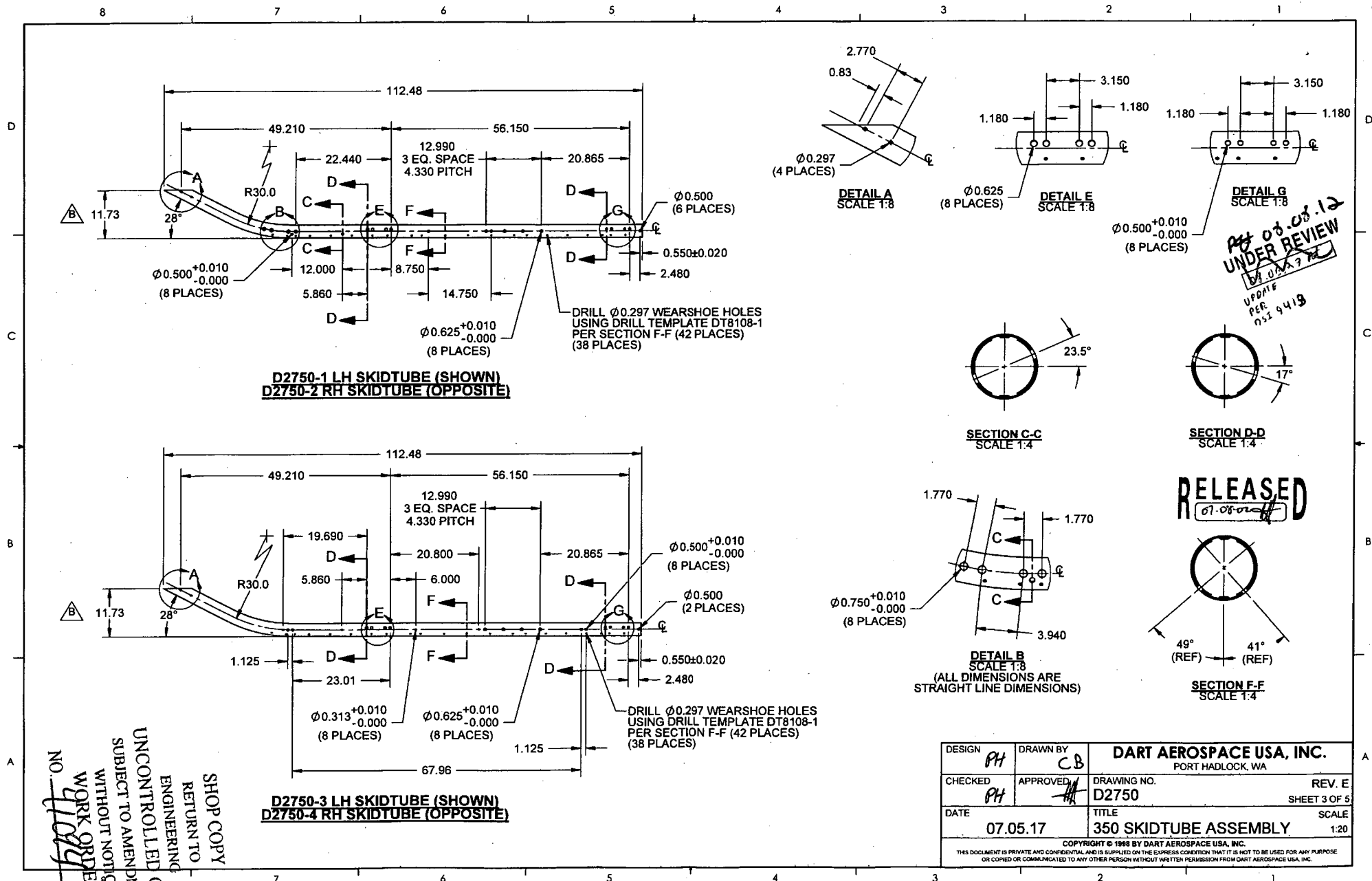
**RELEASED**  
07-08-02 [Signature]

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS. SHOP COPY RETURN TO ENGINEERING
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT. UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 41094
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

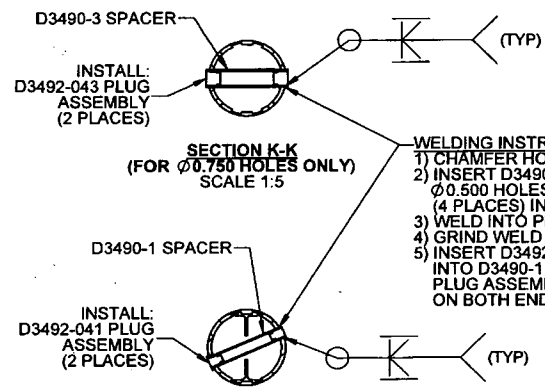
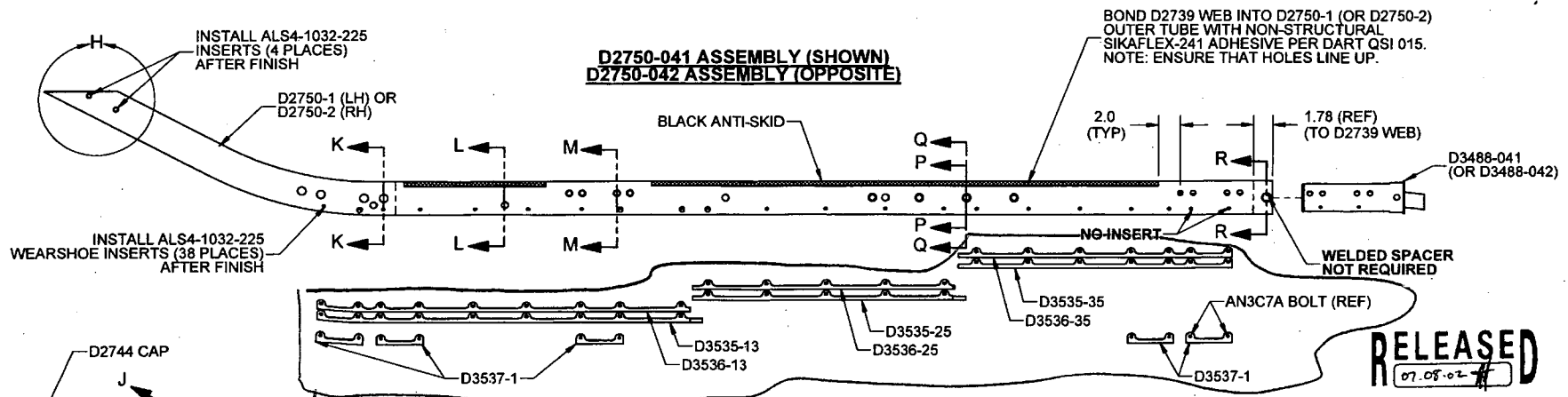
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8 7 6 5 4 3 2 1



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| DATE  | 07.05.17 |          |             | DRAWING NO.              | REV. E       |
|   |          |          |             | D2750                    | SHEET 4 OF 5 |
|   |          |          |             | TITLE                    | SCALE        |
|   |          |          |             | 350 SKIDTUBE ASSEMBLY    | 1:10         |
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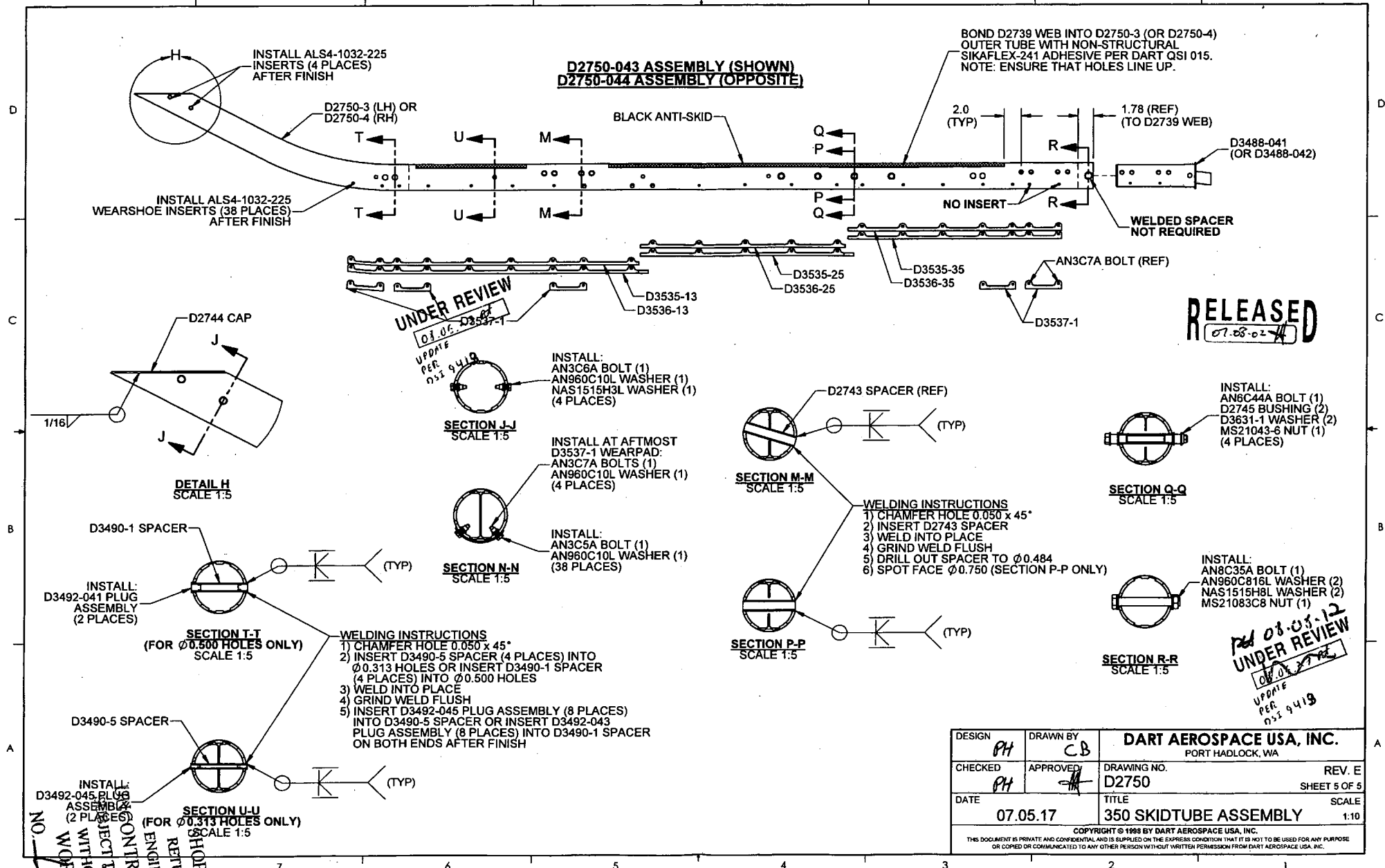
5

4

3

2

1



# DART SERVICE INSTRUCTION

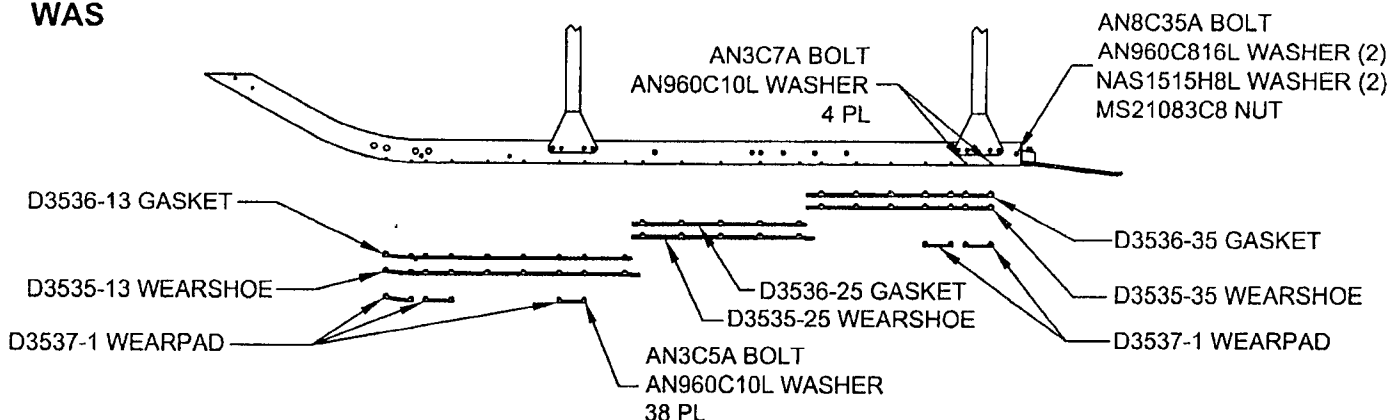
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

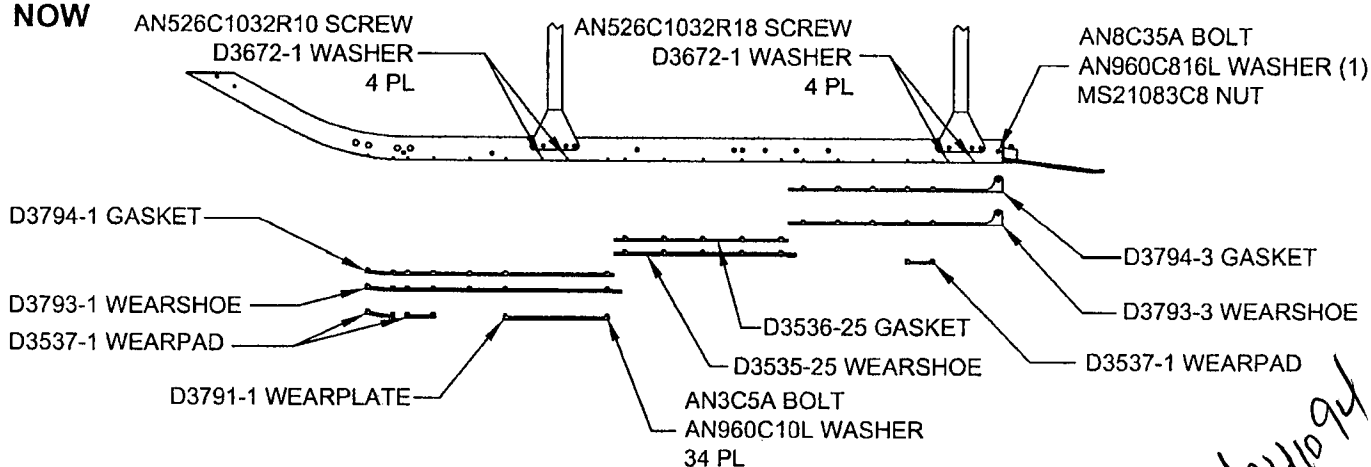
REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

**WAS**



**NOW**



**FIGURE 1 - WEARPLATE MODIFICATION**

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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|            |             |  |              |
|------------|-------------|--|--------------|
| A          | NEW ISSUE   | PH   | 08.05.14     |
| REV.       | DESCRIPTION | BY   | DATE         |
| DESIGN     | PH          | <b>DART AEROSPACE USA, INC</b><br>PORT HADLOCK, WA   |              |
| DRAWN      | PH          |  |              |
| CHECKED    | A           | DRAWING NO.  | REV. A       |
| MFG. APPR. | N/A         | DSI 9413   | SHEET 1 OF 3 |
| APPROVED   | H           | TITLE  | SCALE        |
| DE APPR.   | H           | WEARSHOE MODIFICATION  | NTS          |
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

| Item | Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-014 | Part Number  | Description  |
|------|-------------|-------------|-------------|-------------|--------------|--|
|      | X           |             |             |             | D350-636-011 | SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE |
|      |             | X           |             |             | D350-636-012 | SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE |
|      |             |             | X           |             | D350-636-013 | SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE      |
|      |             |             |             | X           | D350-636-014 | SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE      |
| *6A  | 1           | 1           | 1           | 1           | AN960C816L   | WASHER   |
| 6B   | 2           | 2           | 2           | 2           | NAS1515H8L   | WASHER   |
| *22  | 2           | 2           | 2           | 2           | D3537-1      | WEARPAD  |
| 23A  | 1           | 1           | 1           | 1           | D3535-13     | WEARSHOE   |
| 23B  | 1           | 1           | 1           | 1           | D3536-13     | GASKET   |
| 25A  | 1           | 1           | 1           | 1           | D3535-35     | WEARSHOE   |
| 25B  | 1           | 1           | 1           | 1           | D3536-35     | GASKET   |
| *26A | 4           | 4           | 4           | 4           | AN3C5A       | BOLT   |
| *26B | 4           | 4           | 4           | 4           | AN3C7A       | BOLT   |
| *27  | 8           | 8           | 8           | 8           | AN960C10L    | WASHER   |

\*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-014 | Part Number   | Description  |
|-------------|-------------|-------------|-------------|---------------|--|
| X           |             |             |             | D350-636-011  | SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE |
|             | X           |             |             | D350-636-012  | SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE |
|             |             | X           |             | D350-636-013  | SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE      |
|             |             |             | X           | D350-636-014  | SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE      |
| 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE  |
| 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3794-1       | GASKET   |
| 1           | 1           | 1           | 1           | D3794-3       | GASKET   |
| 8           | 8           | 8           | 8           | D3672-1       | WASHER   |
| 4           | 4           | 4           | 4           | AN526C1032R10 | SCREW  |
| 4           | 4           | 4           | 4           | AN526C1032R18 | SCREW  |

Wb 41094

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| DRAWN      | PH       |   |              |
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| MFG. APPR. | N/A      | DSI 9413  | SHEET 2 OF 3 |
| APPROVED   | PH       | TITLE   | SCALE        |
| DE APPR.   | PH       | WEARSHOE MODIFICATION   | NTS          |
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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

| Qty<br>-011 | Part Number   | Description               |
|-------------|---------------|---------------------------|
| X           | DSI 9413-011  | WEARSHOE MODIFICATION KIT |
| 1           | D3791-1       | WEARPLATE                 |
| 1           | D3793-1       | WEARSHOE                  |
| 1           | D3793-3       | WEARSHOE                  |
| 1           | D3794-1       | GASKET                    |
| 1           | D3794-3       | GASKET                    |
| 8           | D3672-1       | WASHER                    |
| 4           | AN526C1032R10 | SCREW                     |
| 4           | AN526C1032R18 | SCREW                     |

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. **NOTE:** SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

| Qty<br>-011 | Part Number  | Description  |
|-------------|--------------|--------------|
| X           | D350-636-045 | WEARSHOE KIT |
| 3           | D3537-1      | WEARPAD      |
| 1           | D3535-25     | WEARSHOE     |
| 1           | D3536-25     | GASKET       |
| 1           | D3791-1      | WEARPLATE    |
| 1           | D3793-1      | WEARSHOE     |
| 1           | D3793-3      | WEARSHOE     |
| 1           | D3794-1      | GASKET       |
| 1           | D3794-3      | GASKET       |
| 34          | AN3C5A       | BOLT         |
| 34          | AN960C10L    | WASHER       |

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WORK ORDER  
NO. 41094

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b><br>PORT HADLOCK, WA   |              |
| DRAWN      | PH       |  |              |
| CHECKED    | B        | DRAWING NO.  | REV. A       |
| MFG. APPR. | N/A      | DSI 9413   | SHEET 3 OF 3 |
| APPROVED   | PH       | TITLE  | SCALE        |
| DE APPR.   | PH       | WEARSHOE MODIFICATION  | NTS          |
| DATE       | 08.05.14 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |              |

41094

NO. 165

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berclay Elliot  
Job number: 040696  
Part number: D350 R6 Q1  
Description: 350 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Del Duval Date of Test Coupon 08-08-01

Welder Berclay Elliot Date of Test Coupon 08-08-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld